

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004622**Date Inspected:** 04-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei / Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Bay 3 – New Tower Shop**Visual Testing Before Repair**

This QA Inspector performed an initial visual confirmation of the extent of rejectable indications contained in deck panels designated as DP139-001, DP275-001, and DP382-001. This visual confirmation was performed in conjunction with ABF representative Kevin Chen and ZPMC representative Sun Wei.

Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 25% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The deck panel designation numbers are as follows: DP301-001, DP112-001, DP328-002, and DP085-001.

Bay 2 – New Tower Shop

This QA Inspector observed ZPMC welding personnel performing in gantry Flux Core Arc Welding (FCAW) of longitudinal stiffener plate welds on East Lift 2 / Skin A. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector randomly observed ZPMC qualified welding personnel performing groove welding of weld joint ESD1-SA376A/E-2A filler passes. The personnel were observed welding in the 1G (flat) position utilizing a

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Submerged Arc Welding (SAW) process.

This QA Inspector randomly observed ZPMC qualified welding personnel performing groove welding of weld joint ESD1-SA388A/D-2A filler passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process.

This QA Inspector randomly observed ZPMC qualified welding personnel performing groove welding of weld joint WSD1-SA80D/E-11A filler passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process.

This QA Inspector randomly observed ZPMC qualified welding personnel performing groove welding of weld joint WSD1-SA107A/J-17B filler passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process.

This QA Inspector randomly observed ZPMC qualified welding personnel performing groove welding of weld joint WSD1-SA388A/D-19 filler passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process.

Bay 1 – New Tower Shop

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of tower connection plate welds on SSD1-SA109-2A. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Josh Ishibashi, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
